

Work Order ID 65001

Wednesday, January 05, 2011 1:25:22 PM



Handwritten mark

Page 1

Item ID:	D3220-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Doubler Assembly				Stop	
Start Date:	1/5/2011	Start Qty: 5.00		Cust Item ID:		
Required Date:	1/14/2011	Req'd Qty: 5.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>Handwritten signature</i>	Date:	11-01-5	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3220	B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D3220-1 as per Dwg D3220	Dwg Rev: 3							
3074-00	Prog Rev: B								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

HB11-1-6

(6)

HB11-1-6

Sub 1106

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3220-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 1/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Deburr

2-C'sink D3220-1 as per Dwg D3220

EP 11/10/10

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sub 11/10

76

-041

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

=> 11/10/10

86

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 1/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BR 11-01-11

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3220-041 doubler as per Dwg D3220

E 5/1/19 6

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulalig

46

-011

W/O:		WORK ORDER CHANGES					
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Wednesday, January 05, 2011 1:25:22 PM

Item ID: D3220-041

[illegible][illegible]

Start Date: 1/5/2011 **Start Qty:** 5.00

Required Date: 1/14/2011 **Req'd Qty:** 5.00

Cust Item ID:

Customer:

Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

190

Identify as per dwg & Stock Location: 17

0.00

[illegible]

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Memo

0.00

Quality Control

11/01/19 

11-01-19

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 1:25:26 PM

Page 1

Work Order ID: 65001

Parent Item: D3220-041

Parent Item Name: Doubler Assembly

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

81.3847

0.6926

3.645263

4.2



2024-T3 .050 sheet

1811-1-6

Location

Loc Qty

Loc Code

MAT22

81.3847

111381

11.89

113189

0.3947

114968

69.1

6

MS20426AD3-3

Purchased

No

170

Each

3,717.000

8

40



Rivet

114698
4511/01/19

Location

Loc Qty

Loc Code

ST316

3717

19099

3717

48

MS21059L4

Purchased

No

170

Each

28.0000

4

20



Nutplate

4511/01/19

Location

Loc Qty

Loc Code

ST301

28

114718

28

9

1116582 (1502)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65001
Description: Doubler		Part Number: D3220-1
Inspection Dwg: D3220	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.50	✓		V B02	
14.25	+/-0.030	14.75	✓		T B01	
R0.50	+/-0.030	.50	✓		R.G	
7.00	+/-0.030	7.006	✓		✓	
7.000	+/-0.005	7.000	✓		V	
1.50	+/-0.030	1.498	✓		V	
1.000	+/-0.005	1.000	✓		V	
0.500	+/-0.005	.500	✓		V	
1.000	+/-0.005	1.001	✓		V	
0.316	+0.005/-0.000	.319	✓		V	
0.098	+0.005/-0.000	.102	✓		V	
0.050 thick	+/-0.005	.049	✓		V	
Grain Direction	N/A		✓			

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-1-06	Date: 11/01/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue P/O D3220-041	KJ/RF	
B	10.02.02	Dwg Rev updated	KJ [Signature]	[Signature]

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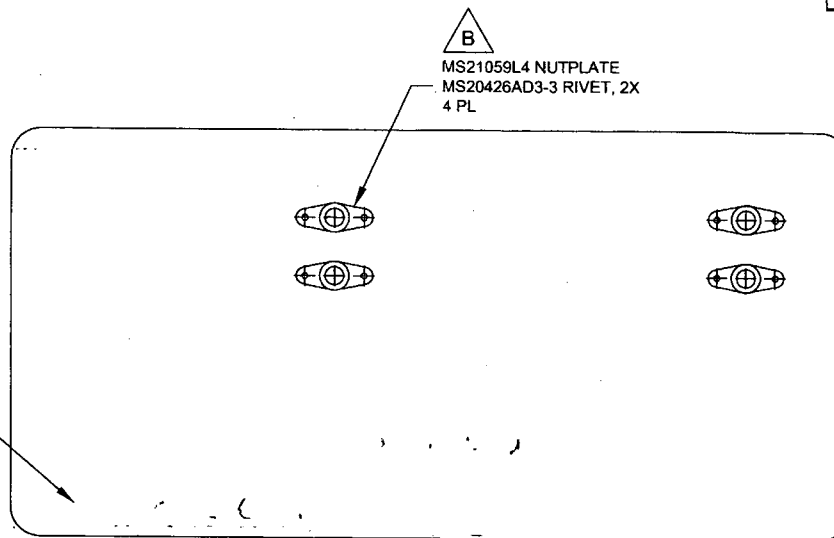
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65001

B9 11-01-5



D3220-1/2 DOUBLER

**D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

RELEASED
2009-09-09

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø.316 WAS Ø.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025		RF	09.07.08
A	NEW ISSUE		CP	03.10.16
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3220 TITLE DOUBLER DATE 09.07.08		
DRAWN	RF			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>	REV. B SHEET 1 OF 4 SCALE NTS		
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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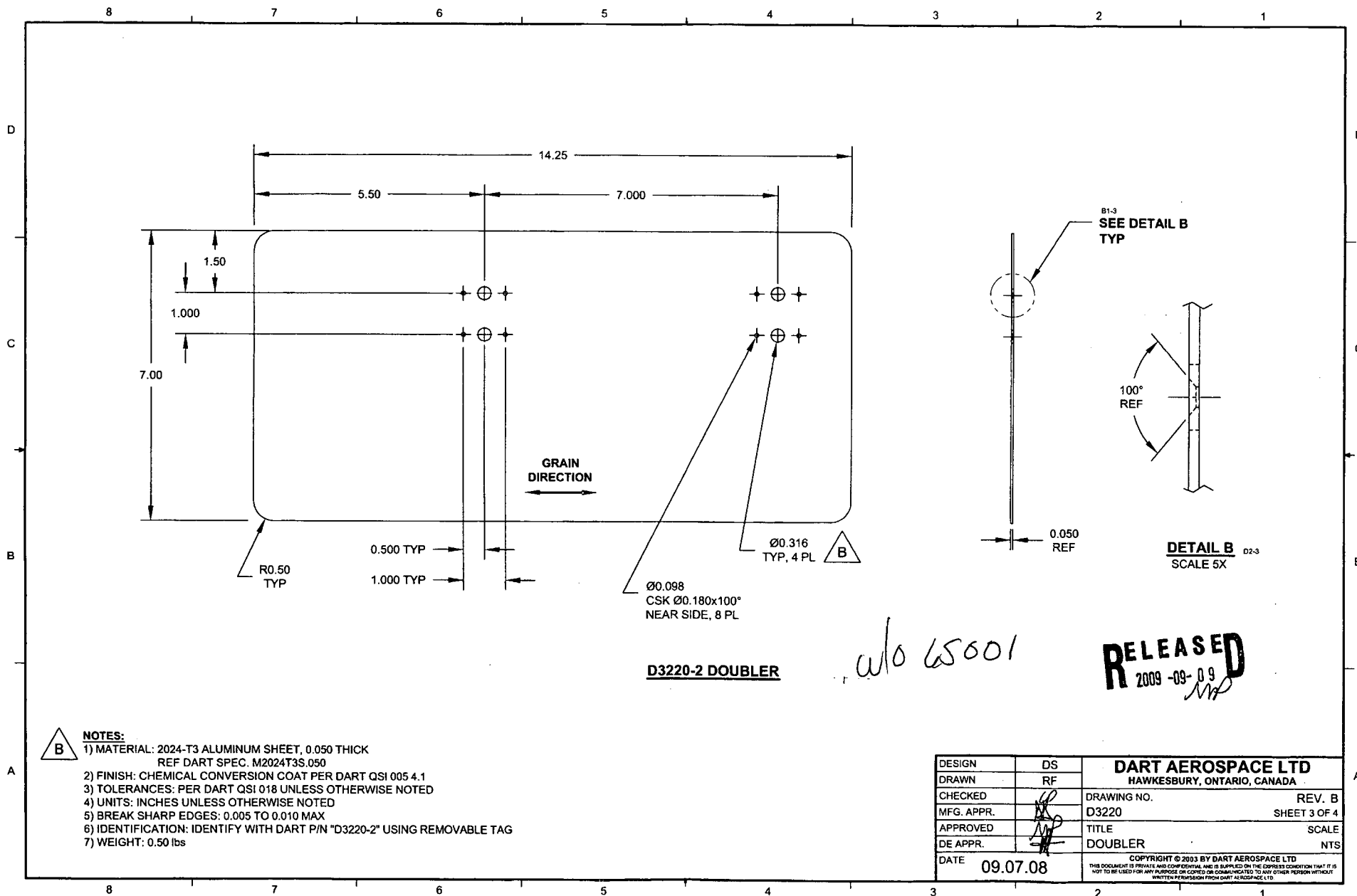
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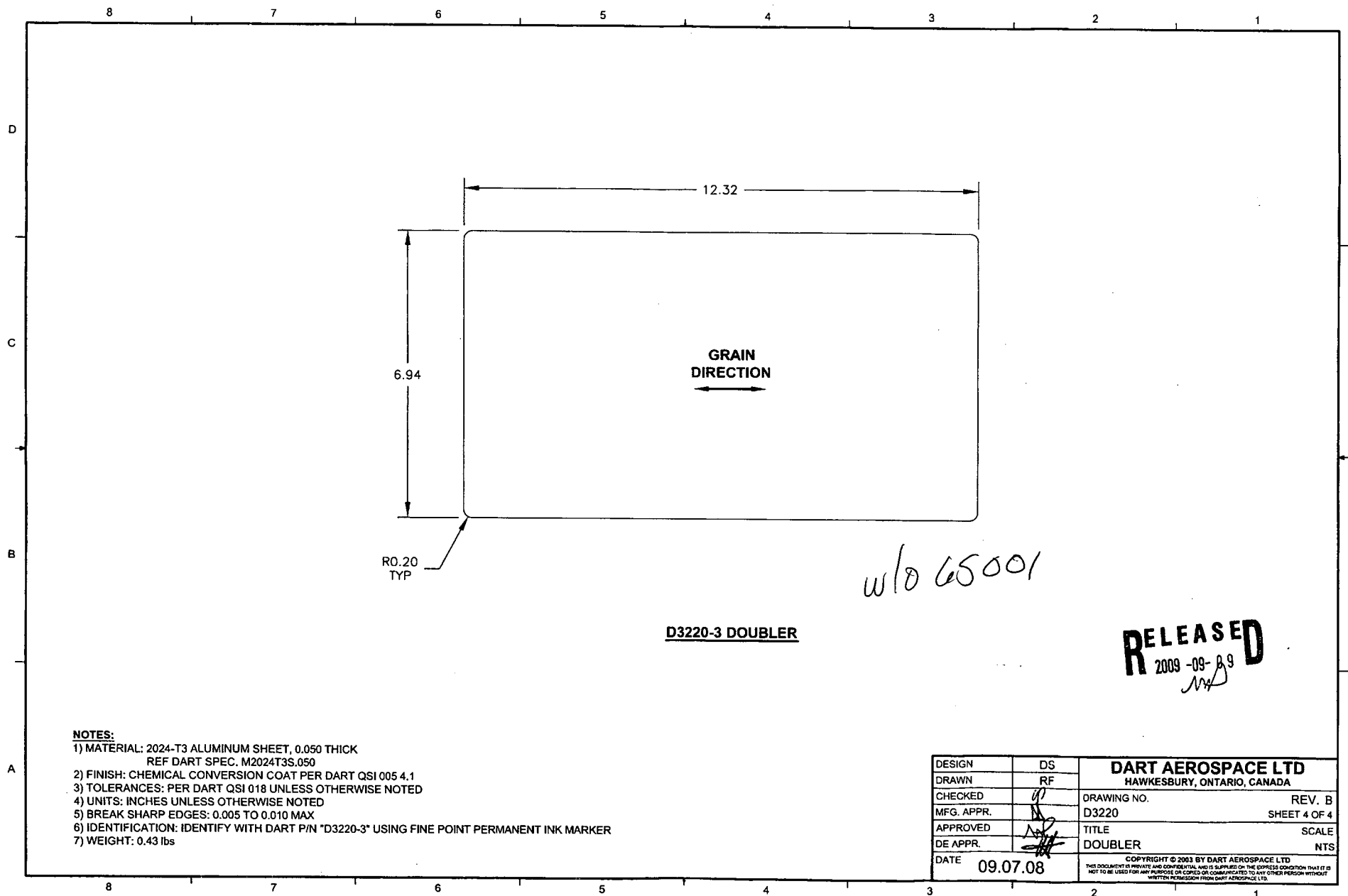
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DT	DRAWING NO.	REV. B
MFG. APPR.	DT	D3220	SHEET 4 OF 4
APPROVED	DT	TITLE	SCALE
DE APPR.	DT	DOUBLER	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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